

Date: Thursday, 3/16/2006 10:37:47 AM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR SUPPORT
Job Number	: 26271		
Estimate Number	: 12305		
P.O. Number	:	Part Number	: D34715
This Issue	: 3/16/2006	S.O. No. :	Drawing Number : D3471 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Type	: SMALL /MED FAB
Previous Run	:	Drawing Revision	: A
		Material	:
Written By	:	Due Date	: 3/31/2006
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: est rev A 06/03/02 New issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S032	2024-T3 .032 sheet
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Comment: Qty.: 0.1040 sf(s)/Unit Total : 0.1040 sf(s)  
2024-T3 .032 sheet

2.0	SHEAR	SHEAR
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Comment: SHEAR  
Cut part as per dwg D3471

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-Deburr

2-Bend as per dwg D3471

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** BLOWER MOTOR SUPPORT

**Job Number:** 26271

**Part Number:** D34715

Job Number:



**Seq. #:**

**Machine Or Operation:**

**Description :**

6.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0

DC

DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	


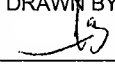
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

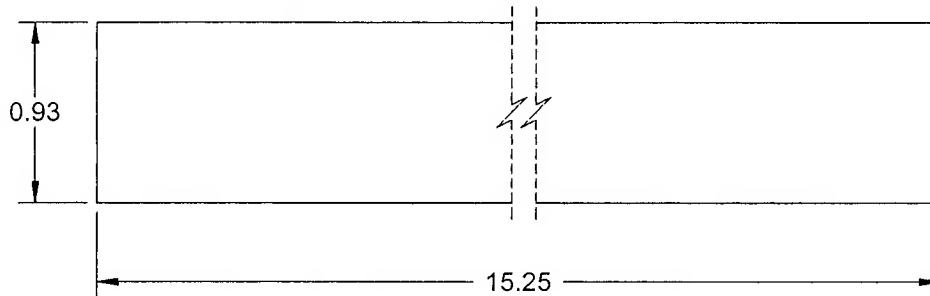
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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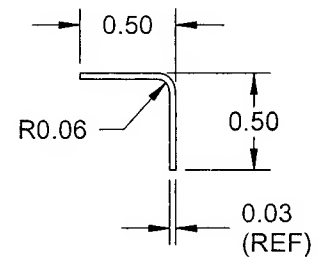
**NOTE:** Date & initial all entries

PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 5 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:1



**D3471-5F STIFFENER FLAT PATTERN**



**D3471-5 STIFFENER  
BENDING DETAIL**

**D3471-5 STIFFENER**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26271

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